

Date Wednesday, 15/08/2007 4:04:34 PM  
 User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE ASSEMBLY
Job Number	: 33958B	Part Number	: D2282043
Estimate Number	: 11180	Drawing Number	: D2282 REV E
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2007	Type	: SMALL /MED FAB
Prsh Rev.	: NC	Drawing Revision	: E
First Issue	: N/A	Material	: N/A
Previous Run	: 33832	Due Date	: 22/09/2007
Written By	:	Qty:	100
Checked & Approved By	:	Um:	Each
Comment	: Est Rev:A	Removed from 9 Digit	05-12-02 JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2281	Jack Saddle	  Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2281 Saddle B33828 X63
2.0	D22827	Tube	  Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2282-7 tube B34183
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	  Comment: LARGE FABRICATION RESOURCE 1 1-Weld as per D2282-043 Saddle Assembly Grind chamfers and ensure full penetration. A/R ER316L SS Filling Rod M105138 Dwg Rev: E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:04:34 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 33958B

Part Number: D2282043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0	DO NOT USE	WELD INSPECTION
-----	------------	-----------------



Comment: WELD INSPECTION

1107/10/01 (37)  
PD 07.09.26 (63) 140

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1



Tumble

SAY 07/10-04 110

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

2/10/05 X 110

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1



Identify and Stock

Location: G-A

SB 07-10/08 110

8.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE



110 07/10/11

Job Completion



U 07-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

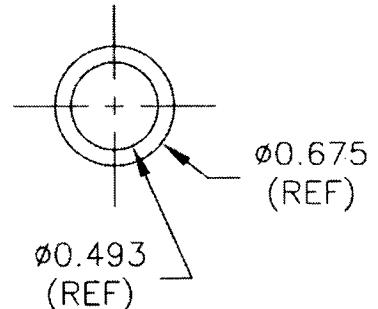
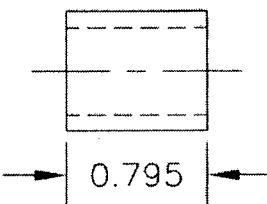
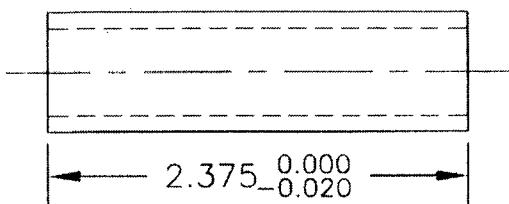
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282 REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1

*RELEASED  
BS/09/16*

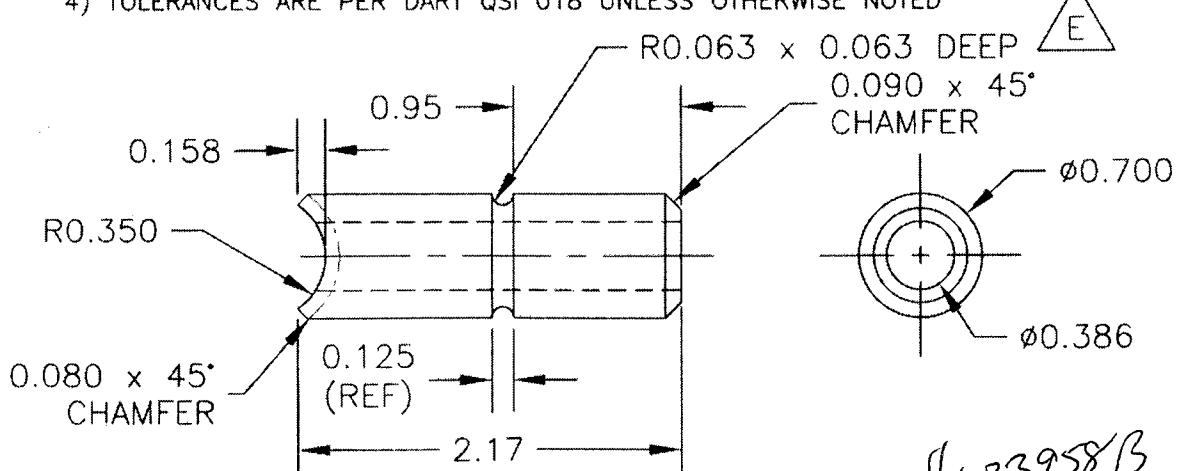


D2282-3

D2282-7

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

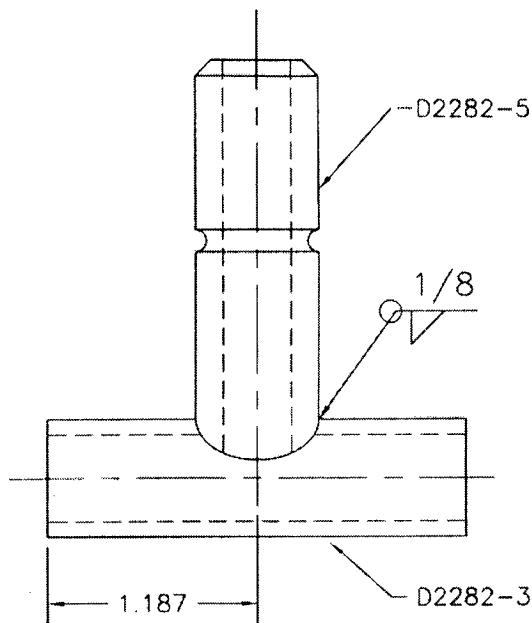
*W/8 33958/B*

D2282-5 STEM:

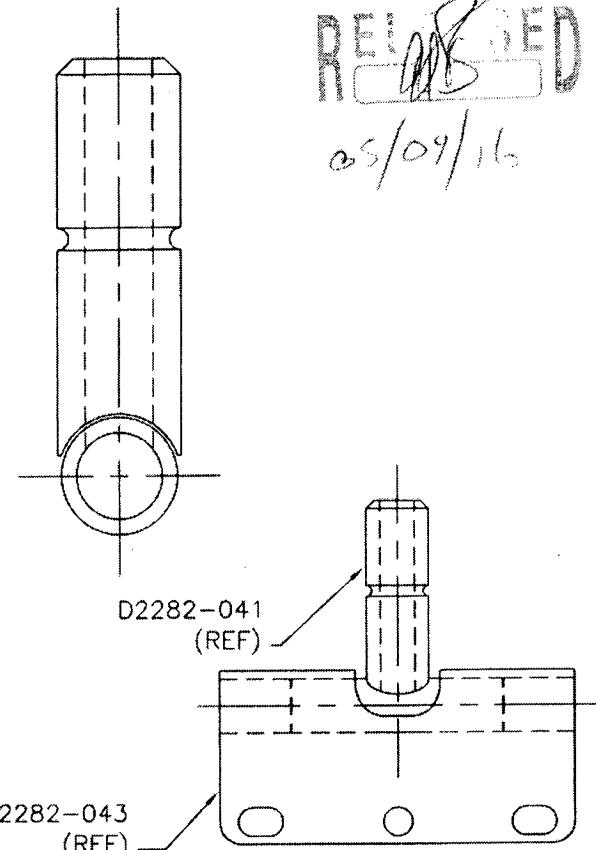
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



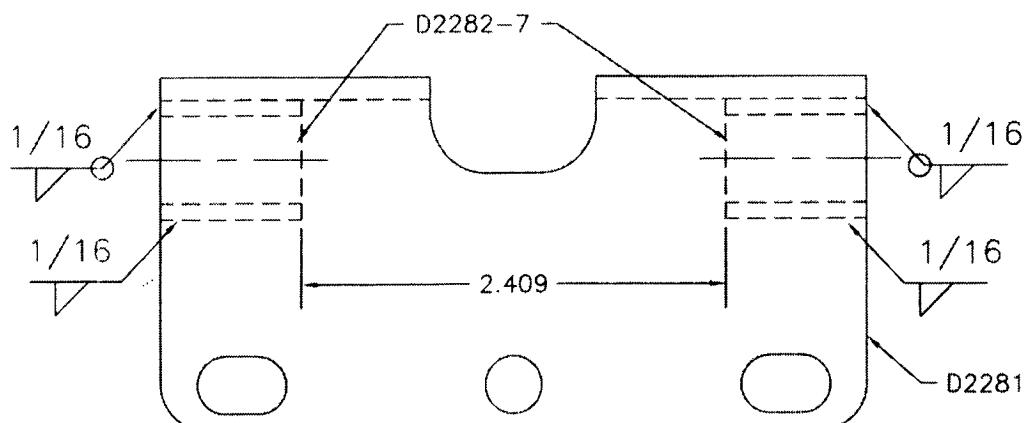
DESIGN BW	DRAWN BY <i>RP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

